

Date: Wednesday, 10/24/2007 4:00:44 PM
 User: Jean-Luc Menard

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BALL STUD
Job Number : 32053	
Estimate Number : 12841	
P.O. Number : <i>N/A</i>	Part Number : D36221
This Issue : 10/24/2007 S.O. No. : <i>N/A</i>	Drawing Number : <i>UNDER REVIEW</i> <i>REV A</i> <i>Jul 10-24</i>
Prsht Rev. : NC	Project Number : AC0001
First Issue : 4/24/2007 Type : MACHINED PARTS	Drawing Revision : UR
Previous Run :	Material : <i>N/A</i>
Written By : <i>JLM 07-10-24</i>	Due Date : 5/1/2007
Checked & Approved By :	Qty: <i>50</i> Um: Each
Comment : Est Rev:A New Issue 07-04-24 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303H0500	303 HEX BAR
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Comment: Qty.: 0.1134 f(s)/Unit Total : 0.2268 f(s)

303 HEX BAR .500"

Batch: *M102286* *4'*

DEP 07/10/29 *20 07/10/30*

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA686 & DWG D3622 ,

FOLIO REV: *A*

DWG REV: *A*

2-DEBURR AS REQUIRED

DEP 07/10/29 *20 07/10/30*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

20 02/10/30 *(52)*

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L 07/11/01

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST110*

(X52)

07/11/02 AS / 10

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BALL STUD

Job Number: 32053

Part Number: D36221

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



52

Comment: FINAL INSPECTION/W/O RELEASE

20/11/02

Job Completion

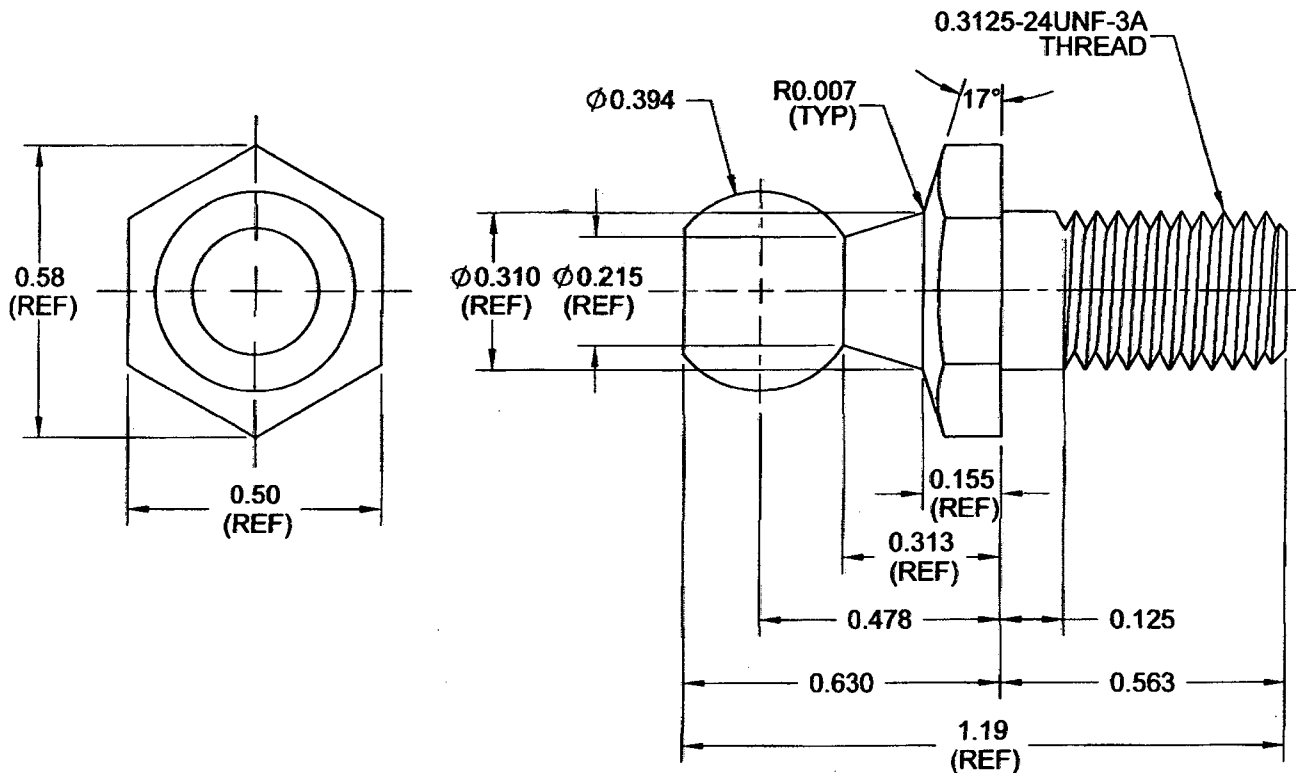


U 07.11.02

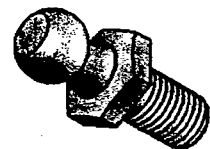
DART**RELEASED**
07.07.11

Per BCW# 1001

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D3622	REV. A SHEET 1 OF 1
DATE 07.04.13		TITLE BALL STUD	SCALE NTS
REV A	DATE 07.04.13	DESCRIPTION NEW ISSUE	

**D3622-1 BALL STUD****NOTES:**

- 1) MATERIAL: AISI 303 HEX BAR (REF. DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

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DART AEROSPACE LTD		Work Order: 32053
Description: Ball Stud		Part Number: D36221
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58 (REF)	± 0.030	0.572	✓			
0.50 (REF)	± 0.030	0.499	✓			
1.19 (REF)	± 0.030	1.194	✓			
Ø0.310 (REF)	± 0.010	.310	✓			
Ø0.215 (REF)	± 0.010	0.223	✓			
0.155 (REF)	± 0.010	0.155	✓			
0.313 (REF)	± 0.010	.317	✓			
0.630	± 0.010	0.630	✓			
0.563	± 0.010	0.563	✓			
0.478	± 0.010	.478	✓			
0.125	± 0.010	0.125	✓			
Ø0.394	± 0.010	0.391	✓			
R0.007	± 0.010	0.008	✓			
17°	$\pm 1/2^\circ$	17°	✓			
5/16-24 UNF-3A	NA	5/16-24 UNF-3A	✓			

Measured by: <u>RP</u>	Audited by: <u>J.F.</u>	Prototype Approval:
Date: <u>07/10/30</u>	Date: <u>07/10/30</u>	Date:
Rev	Date	Change
A		New Issue
Revised by		Approved
KJ/RF		